

Work Order ID 153617

Tuesday, November 22, 2016 1:50:48 PM

153617

Page 1

Item ID: PB67-43001-59

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Adjustable Attachment Arm

Start Date: 11/22/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: UMF Date: 16-11-22

Tooling:

Date:

Run Start

NR1

QC: Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001-59	D
--------------	---

100

Weld per dwg A/R Aluminum rod Batch: 134826

0.00

100

Large Fab

Large Fab

Memo

0.10

Large Fab

1- Weld -105 to -113 as per dwg and grind weld flush

2- Weld 119, -117 and -115 to -113 as per dwg PB67-43001

3- Pick two -271 and weld one on each side of tubing but only one need to

1 DEC 13 2016DAS
24
9-89

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

① 16.12.13DAS
9
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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[illegible]

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[illegible]

Work Order ID 153617

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Item ID: PB67-43001-59 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Adjustable Attachment Arm
Start Date: 11/22/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/2/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			
190									JAN 10 2017
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

JAN 09 2017

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Work Order ID: 153617

153617

Parent Item: PB67-43001-59

PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 11/22/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-18 new issue DD verified by:ec
IPP Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified
by: eC IPP RevC 10.09.29
per revC dwg EC verified by:DD IPP REV:D 16.11.22 DWG
REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-23		Purchased	No			160	Each	48.0000	2	2			
MS27039-1-23									**				
SCREW													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST279		48			CMF 10-11-24				
				m135043		48							
NAS1149DN616J		Purchased	No			160	Each	173.0000	4	4			
NAS1149DN616.J									**				
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST265		173			CMF 10-11-24				
				M127726		173							
PB67-43001-121		Manufactured	No			160	Each	0.0000	1	1			
PB67-43001-121									**		153615 CMF 10-12-0		
Square Sleeve													
PB67-43001-267		Manufactured	No			160	Each	0.0000	1	1			
PB67-43001-267									**		152082		
Pad Attachment Assembly													

CMF 16-11-24

CMF 16-11-24

153615 CMF 16-12-07.

152082

CMF
16-1-9.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 153617

153617

Parent Item: PB67-43001-59

PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 11/22/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

30345T21

Purchased

No

160

Each

32.0000

2

2

30345T21

LANYARD

Location

Loc Qty

Loc Code

ST570

2

M132610

2

ST581

30

M135014

12

M135098

18

CMF 16-11-24

BSP43

Purchased

No

160

Each

22.0000

4

4

BSP43

RIVET

Location

Loc Qty

Loc Code

ST558

22

M132703

22

CMF 16-11-24

MS17984-C413

Purchased

No

160

Each

27.0000

2

2

MS17984-C413

Quick Release Pin

Location

Loc Qty

Loc Code

over005

20

150872

10

151622

10

ST315

7

148840

7

CMF 16-11-24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 153617

153617

Parent Item: PB67-43001-59

PR67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 11/22/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

160

Each

2,331.000

2

2

MS21042L3

Nut

Location

Loc Qty

Loc Code

CCK007

600

M136192

600

FP001

7

M130922

7

GA

196

m134360

108

m135135

88

OVER007

600

M136044

600

ST303

928

m135767

328

m135945

600

MF 16-11-24

NAS1149DN416J

Purchased

No

160

Each

1,251.000

4

4

NAS1149DN416J

Washer

*m135948 SP
Feb-4*

Location

Loc Qty

Loc Code

GA

524

124983

524

ST265

727

124968

727

MF 16-11-24

PB67-43001-105

Manufactured

No

100

Each

5.0000

1

1

PR67-43001-105

Plug

Location

Loc Qty

Loc Code

Mezz2

5

139144

5

MF 16-11-24

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 153617

153617

Parent Item: PB67-43001-59

PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 11/22/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-113

Manufactured No

100

Each

0.0000

1

1

PB67-43001-113

Square Tube

**

153616 CMF 16-12-07

PB67-43001-115

Manufactured No

100

Each

3.0000

1

1

PB67-43001-115

Tube End Plate

**

Location

Loc Qty

Loc Code

Mezz2

3

139146

3

CMF 16-11-24

PB67-43001-117

Manufactured No

100

Each

2.0000

1

1

PB67-43001-117

Hook Plate

**

Location

Loc Qty

Loc Code

Mezz2

2

139147

2

CMF 16-11-24

PB67-43001-119

Manufactured No

100

Each

3.0000

1

1

PB67-43001-119

End Cap Clevis

**

Location

Loc Qty

Loc Code

Mezz2

3

139150

3

CMF 16-11-24

PB67-43001-271

Manufactured No

100

Each

4.0000

1

1

PB67-43001-271

Doubler

**

Location

Loc Qty

Loc Code

Mezz2

4

139153

4

CMF 16-11-24

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 153617

153617

Parent Item: PB67-43001-59

PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 11/22/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-275

Manufactured No

160

Each

4.0000

1

1

PB67-43001-275

Doubler

Location

Loc Qty

Loc Code

Mezz2

4

106423

4

MS-6-11-24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

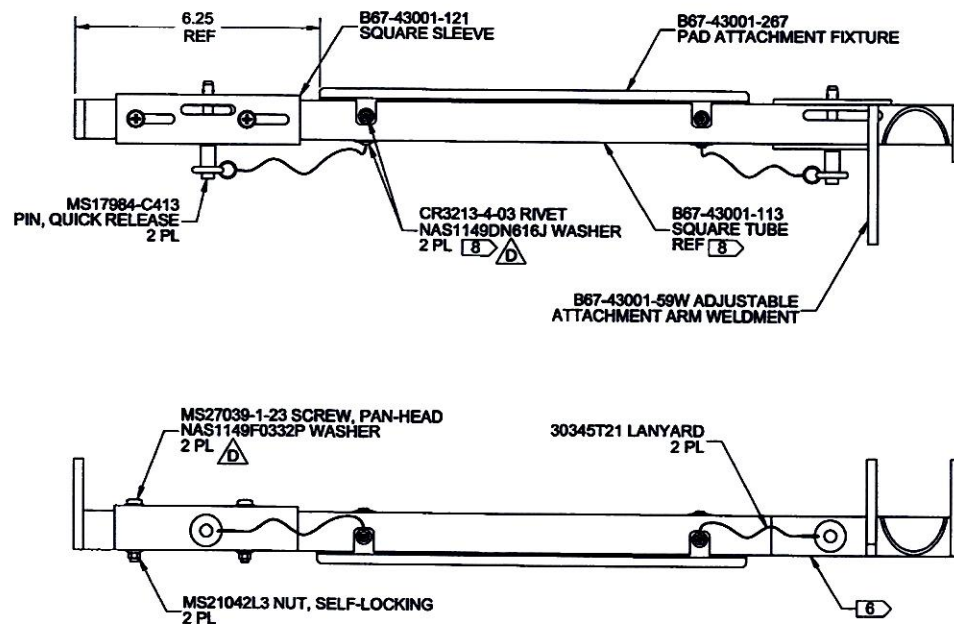


QA Closed: _____ Date: _____

Work Order update only ☐

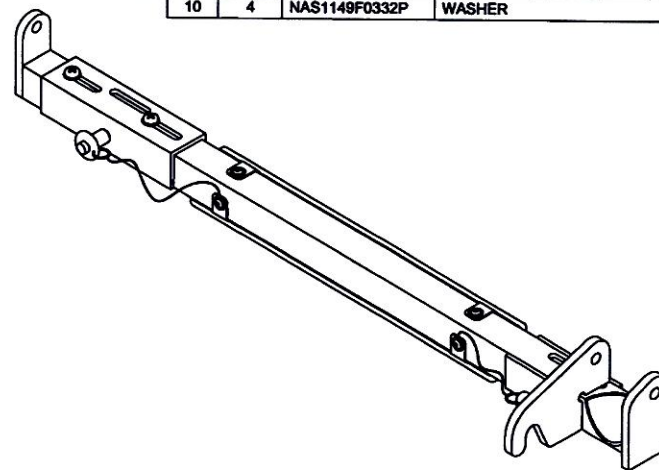
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

MF
#153617
16-11-22



B67-43001-59 ADJUSTABLE ATTACHMENT ARM

ITEM	QTY -59	P/N	DESCRIPTION
	X	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
1	1	B67-43001-59W	ADJUSTABLE ATTACHMENT ARM WELDMENT
2	1	B67-43001-121	SQUARE SLEEVE
3	1	B67-43001-267	PAD ATTACHMENT FIXTURE
4	2	30345T21	LANYARD
5	4	CR3213-4-03	RIVET (OR BSP43-4-3)
6	2	MS17984-C413	PIN, QUICK RELEASE
7	2	MS27039-1-23	SCREW, PAN-HEAD
8	2	MS21042L3	NUT, SELF-LOCKING
9	4	NAS1149DN616J	WASHER
10	4	NAS1149F0332P	WASHER



- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-59" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.21 lbs
 - 8) FOLD -267 TABS OVER AND TRANSFER DRILL $\phi 0.130$ FROM -267 TO -113 PRIOR TO INSTALL CR3213-4-03 RIVETS.

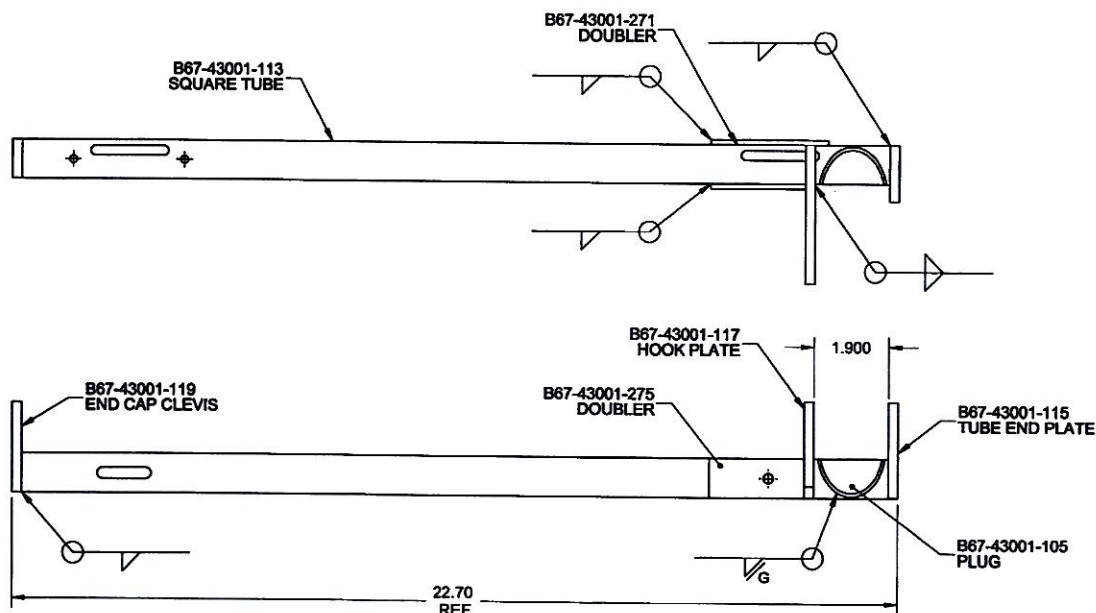
D	CHANGE HARDWARE MS27039-1-23 WAS MS27039-1-22 (ZNB7-1). NAS1149D0616J WAS NAS1149D0332J (ZNC6-1). REASON PAR15-437	SAD	16.10.17	
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 14 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR08-011.	MB	10.04.27	
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	SAD			
CHECKED	MB	DRAWING NO.	REV. D	
MFG. APPR.	DD	B67-43001-59	SHEET 1 OF 2	
APPROVED	WM	TITLE	SCALE	
DE APPR.	N/A	ADJUSTABLE ATTACHMENT ARM	NTS	
DATE	16.10.17	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED TO THE EXTENT PERMITTED BY IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR UNCLASSIFIED INFORMATION SERVICE ANYWHERE IN THE WORLD		

RELEASED
2016-11-09
EEN 6-55

APPROVED

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ITEM	QTY -59W	P/N	DESCRIPTION
1	X	B67-43001-59W	ADJUSTABLE ATTACHMENT ARM WELDMENT
3	1	B67-43001-105	PLUG
4	1	B67-43001-113	SQUARE TUBE
5	1	B67-43001-115	TUBE END PLATE
6	1	B67-43001-117	HOOK PLATE
7	1	B67-43001-119	END CAP CLEVIS
8	1	B67-43001-271	DOUBLER
9	1	B67-43001-275	DOUBLER



B67-43001-59W ADJUSTABLE ATTACHMENT ARM WELDMENT
(WELDING DETAIL)

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-59	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	ADJUSTABLE ATTACHMENT ARM	NTS
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- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.26 lbs
 - 8) WELDING: PER QSI 004
 - 9) MASK ALL HOLES AND OPENINGS PRIOR TO POWDER COAT

RELEASE
2016-11-09
APPROVED